
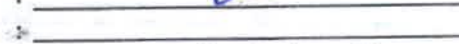


Date: Tuesday, 1/3/2006 4:15:01 PM
User: Kim Johnston

Process Sheet

SLIP

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 25352 -1	
Estimate Number : 10034	
P.O. Number : N/A	Part Number : D6101005
This Issue : 1/3/2006 S.O. No. : N/A	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25351	Material : N/A
Written By : 	Due Date : 11/15/2006 Qty: 100 Um: Each
Checked & Approved By : 	
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 00000339

06/01/04

a) Description: Alluminum billet

b) 5.00" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 5.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

7075-T7351 8.25X5.0X2.5

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

06/11/04 50
06/11/14 50

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

06/11/30 50



File: Tuesday, 1/3/2006 4:15:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001, Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25352

Part Number: D6101005

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 4/19/29

6.0

DC

DOCUMENT CONTROL



50

Comment: DOCUMENT CONTROL

Inspection Level 21

D6611130

Job Completion



C 20611130

SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131	
SOLD TO: AM CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131	
CUSTOMER PO NUMBER: 01-83475	WORK PACKAGE:
CUSTOMER PART NUMBER: 6873 A97075-80	SHIP RUN/LOAD ID: 100828/18
GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1042200	LINE ITEM: 1
SHIP DATE: 9-NOV-2006	ALLOY: 7075
CLAD: BARE	TEMPER: T7351
PRODUCT DESCRIPTION: MILL FINISH PLATE	
WEIGHT SHIPPED: 7276 LB	QUANTITY: 4 PCS EST.
B/L NUMBER: 2010362	Gauge: 2.5000 IN
WIDTH: 48.500 IN	LENGTH: 147.000 IN

**KAISER
ALUMINUM**
Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4080392

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev06
BSS 7055/RevA
GSS16100/RevG
PS 21211/RevJ

AMS-QQ-A-250/12
ASTM B 594/Rev02
CSTI 006/RevC
MIL-STD-2154

AMS-STD-2154
BAC 5439/RevH
DPS 4.713/RevN/AmdAF
MMS 159/RevN

Test Code: 4297

Test Results

Lot: 378703A3 Cast 933

Drop 16

Ingot 1

Lot: 37675A3 22072018											
Tensile:	Temper	Dir / # Tests		Ultimate KSI (MPA)			Yield KSI (MPA)		Elongation %		
	T7351	LT / 2 (Min:Max)		89.9 : 70.0 (482 : 483)			58.3 : 58.7 (402 : 405)		10.8 : 11.6		
Conductivity %IACS :				42.4 Min			42.8 Max				
(MS/M) :				24.6 Min			24.8 Max				
Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.17	1.42	0.01	2.48	0.20	5.60	0.01	0.01	0.01	TOT 0.02

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP
DATE REC'D 11.15.06 FAC 6873
APPROVED BY: [Signature]

SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131	
SOLD TO: AM CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131	
CUSTOMER PO NUMBER: 01-83475	WORK PACKAGE:
CUSTOMER PART NUMBER: 6873 A97075-60	SHIP RUN/LOAD ID: 100828/18
GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1042200	LINE ITEM: 1
SHIP DATE: 9-NOV-2006	ALLOY: 7075
CLAD: BARE	TEMPER: T7351
PRODUCT DESCRIPTION: MILL FINISH PLATE	
WEIGHT SHIPPED: 7276 LB	QUANTITY: 4 PCS EST.
B/L NUMBER: 2010362	GAUGE: 2.5000 IN
WIDTH: 48.500 IN	LENGTH: 147.000 IN

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ALUMINUM**
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CERTIFIED TEST REPORT

Serial Number
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Certified Specifications

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MIL-STD-2154

AMS-STD-2154
BAC 5439/RevH
DPS 4.713/RevN/AmdAF
MMS 159/RevN

Test Code: 4297

Test Results

Lot: 378703A3 Cast 933

Drop 16

Ingot 1

Lot: 07070940											
Tensile:	Temper	Dir / # Tests		Ultimate KSI (MPA)			Yield KSI (MPA)		Elongation %		
	T7351	LT / 2 (Min:Max)		69.9 : 70.0 (482 : 483)			58.3 : 58.7 (402 : 405)		10.8 : 11.6		
Conductivity %IACS :				42.4 Min			42.8 Max				
(MS/M) :				24.6 Min			24.8 Max				
Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.17	1.42	0.01	2.48	0.20	5.60	0.01	0.01	0.01	TOT 0.02

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP
DATE REC'D 11.15.06 IAC 6873
APPROVED BY: *[Signature]*

